

Work Order ID 62835

Friday, October 08, 2010 12:50:19 PM



Page 1

Item ID:	D3564-3	Accept		Setup	Start	
Revision ID:						
Item Name:	Wearshoe				Stop	
Start Date:	10/8/2010	Start Qty: 6.00		Cust Item ID:		
Required Date:	10/15/2010	Req'd Qty: 6.00		Customer:		
Reference:						

Approvals:	Process Plan:	<u>14</u>	Date:	<u>10/10/08</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3564	Rev D								

100		FLOW WATER JET	0.00						
	Waterjet								
	FLOW CNC Waterjet								
	304 . 063								
	Memo		0.00						
	1-Cut as per Dwg D3564 ***** (D3564-1F) *****								
	Rev: <u>D</u> □2-Deburr if necessary								

B 10-10-13

(10)

110		QC2- Inspect parts off machine FAI/FAIB	0.00						
	QC								
	Quality Control								
	Memo		0.00						

B 10-10-13

120		QC8- Inspect parts - second check	0.00						
	QC								
	Quality Control								
	Memo		0.00						

5 10/10/14

(710)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62835

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Page 2

Item ID: D3564-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearshoe

Start Date: 10/8/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

0.00

Memo

0.00

Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155 Form Joggle as per Dwg D3564 on brake using Jig DT8157

SB 10/10/25

10

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Ensure joggle as per dwg D3429

8/10/10/25

NO

150



Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

Qty Description Batch A/R 2059B Hardcoat
115879 Weld hardcoat as per Dwg D3437

10-10-27

PTO

W/O: 62835		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/26	40	took one for testing	U	10/27	1	W 10/27	S 10/28

Part No: D3564-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00				9	0		
Quality Control									
200 	Identify as per dwg & Stock Location	0.00							
Packaging	Memo	0.00				9	0	10-11-3	
Packaging									
210 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							10/11/04
Quality Control									

MF
10-11-03

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NOTE: Date & initial all entries

Picklist Print

Friday, October 08, 2010 12:50:23 PM

Page 1

Work Order ID: 62835



Parent Item: D3564-3



Parent Item Name: Wearshoe

Start Date: 10/8/2010

Required Date: 10/15/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-03-08 ec
 IPP Rev:B As per Rev C 07-07-09 JLM
 IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

61.5100

1.1

6.947368

1.1



10-10-13

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT

55.67

111323

0

115688

55.67

MAT20

5.84

115440

5.84

115688

10

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	62835
Description: Wearshoe		Part Number:	D3564-3
Inspection Dwg: D3564	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.225	✓		V 1B0 2	
2.432	+/-0.010	2.437	✓		V	
2.50	+/-0.030	2.50	✓		V	
6.000	+/-0.010	6.00	✓		T B01	
12.104	+/-0.010	12.104	✓		T	
18.000	+/-0.010	18.00	✓		T	
18.000	+/-0.010	18.00	✓		T	
18.00	+/-0.030	18.00	✓		T	
9.00	+/-0.030	9.00	✓		T	
11.50	+/-0.030	11.50	✓		T	
0.300 x 0.300	+/-0.010	300x301	✓		V	
Ø0.188	+0.005/-0.001	.189	✓		V	
R0.375	+/-0.010	.375	✓		R.G	
0.063	+/-0.010	.060	✓		V	

Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 10-10-13	Date: 10/10/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	
B	08.09.04	Dwg Rev updated	KJ/DD	

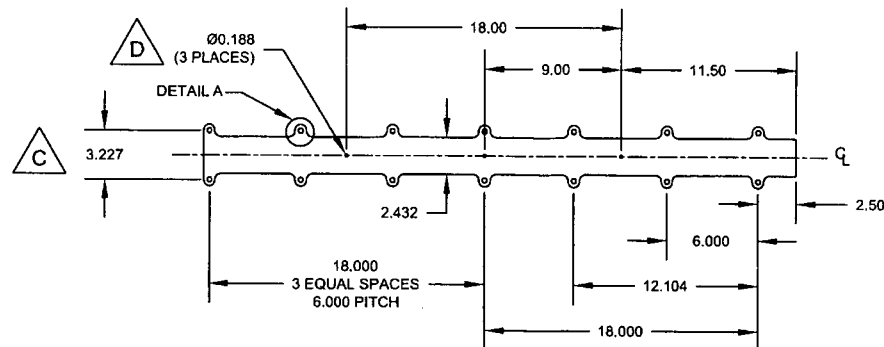
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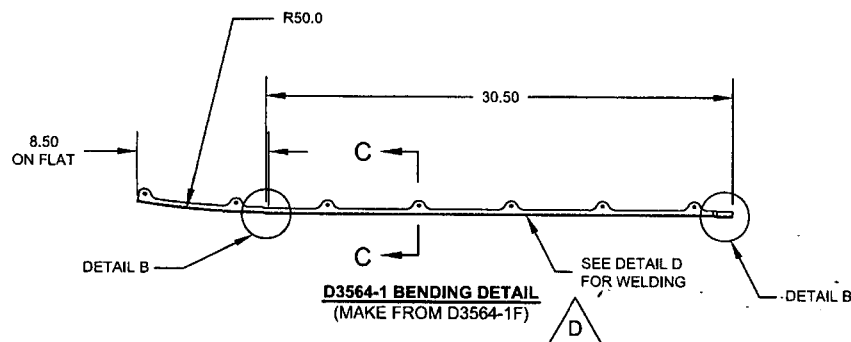
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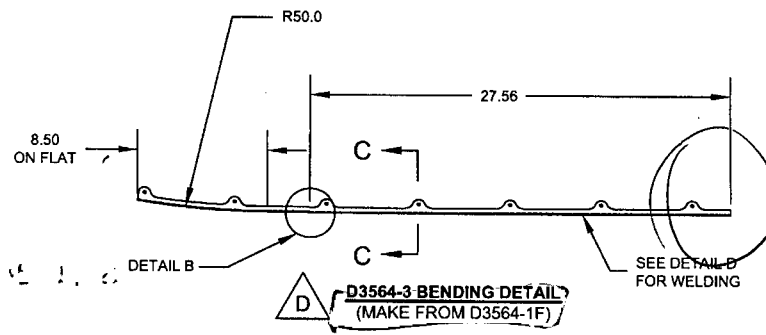
NOTE: Date & initial all entries



D3564-1F FLAT PATTERN



D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT Q

WEIGHTS:

D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

SHOP COPY
RETURN
ENTER
UNCONTROLLED
SUBJECT TO
WITH
WORK ORDER
NO. 62835
B/10-10-8

RELEASED
07.09.04

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 1 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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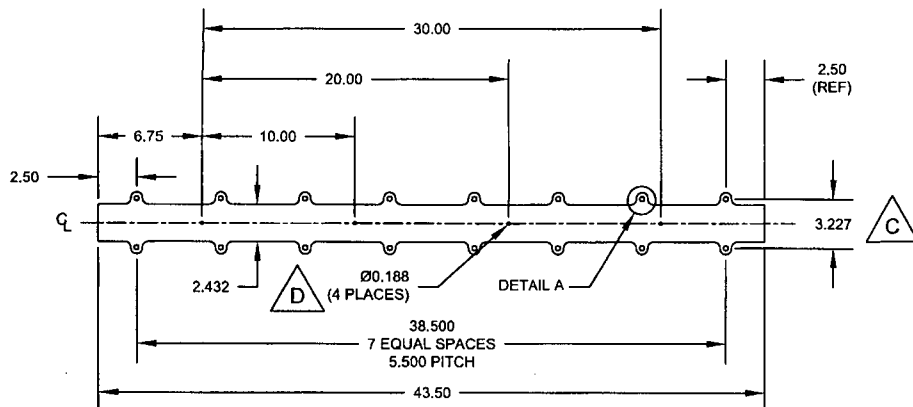
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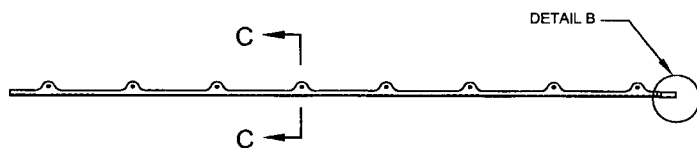
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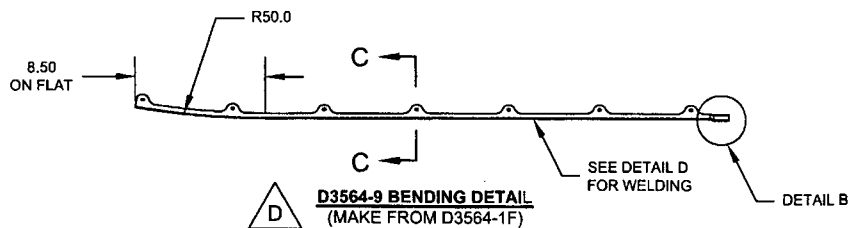
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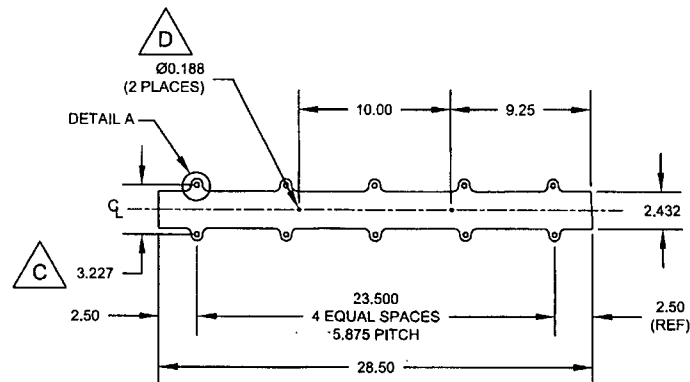
D3564-5F FLAT PATTERN



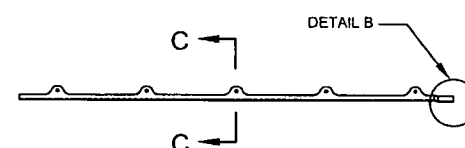
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



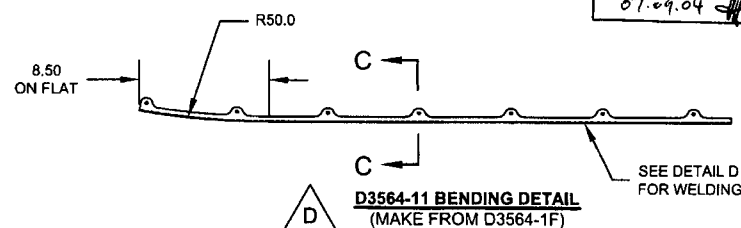
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

RELEASED

07.09.04

all 62835

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO. D3564	REV. D
MFG. APPR.	PH	SHEET 2 OF 3	
APPROVED	PH	TITLE WEARSHOE	SCALE 1:8
DE APPR.	PH	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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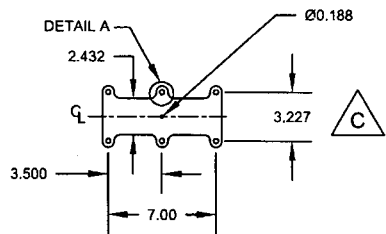
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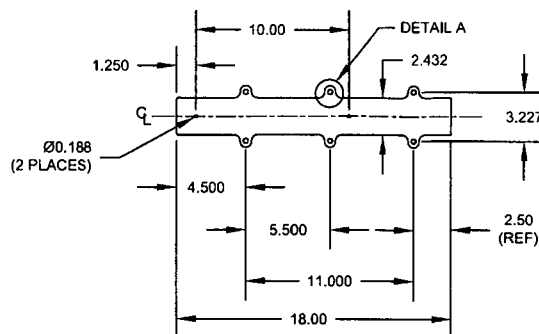
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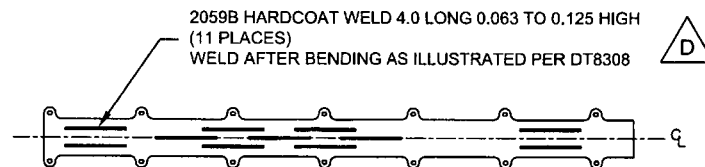
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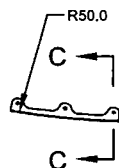
D3564-13F FLAT PATTERN



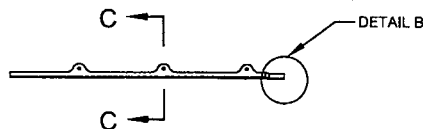
D3564-15F FLAT PATTERN



DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)



D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)

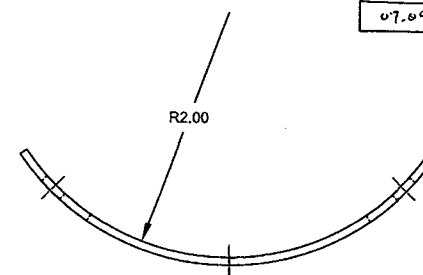


D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)

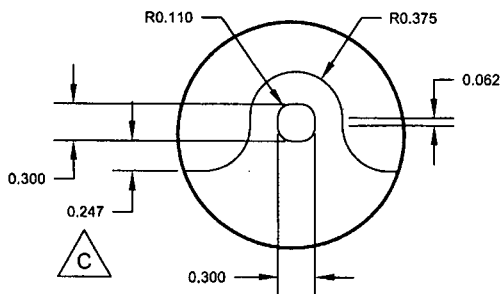
w/o 62835

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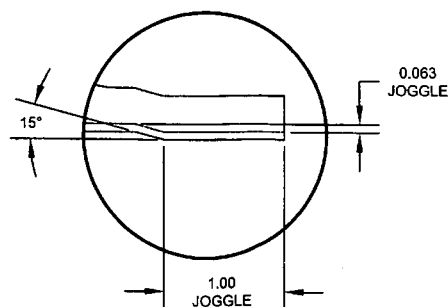
07.09.04



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

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DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO. D3564	REV. D
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8 7 6 5 4 3 2 1

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